

5/43

66 out

DART AEROSPACE LTD	Work Order:	24399
Description: Lug	Part Number:	D2230-3
Drawing: D2230 Rev. F	Qty:	300 200

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	JG	05.10.03	200
2	METAL	Cut D2423 extrusion to 0.82"	JG	05/10/08	68/200
3	HAAS PG	Machine per folio D2230-3 Batch: M23779 Check for crack while loading into the machine Issue: 2008788	JG	05-10-08	200
4	QC RG	Inspect Level 2 Review + inspect for transit damage	JG	05-10-08	200
5	QC	Inspect Level 3	JG	05/11/15	300
6	METAL	Tumble and deburr rough edges after tumbling if applicable	JG	05-12-13	300
7	METAL	Acid etch and Alodine per QSI 005 4.1	JG	05/12/14	300
8	QC	Inspect Level 5	JG	05/12/28	300
9	FINISHING	Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3	JG	05-12-30	300
10	QC	Inspect Level 3	JG	06 01 10	300
11	STORES	Identify and stock	JG	06-01-11	300
12	EXPEDITING	Close W/O Job Cost / Part	JG	06/01/12	293
		Luc 16y	JG	06/01/13	293
		505 06/01/13 293	JG	06/01/13	293

Rev	Date	Change	Revised By	Approved
A	97.02.21	New Issue		
B	98.06.01	Re-Format	KB	
C	00.01.27	Re-Format, added level 2 insp., Rev. F (mpp 2022)	EC	
D	00.05.18	Added inspection level 8, and removed P/O for powder coat	EC	

RELEASED

EC 00.05.24

RF
03.05.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 06/01/13

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

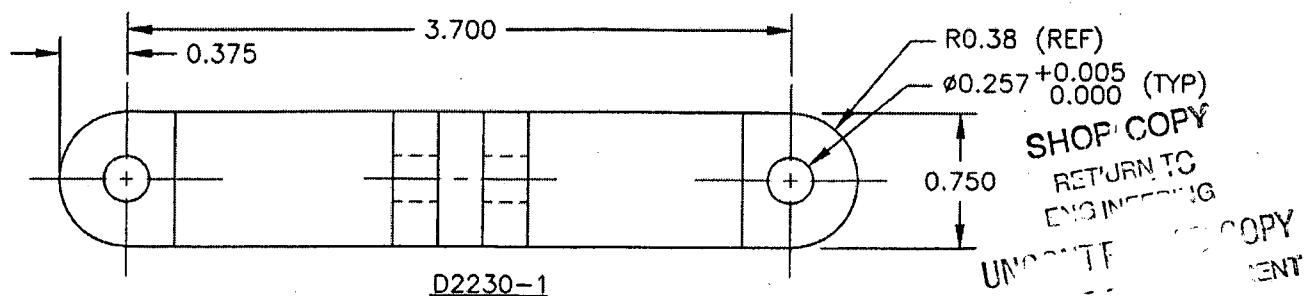
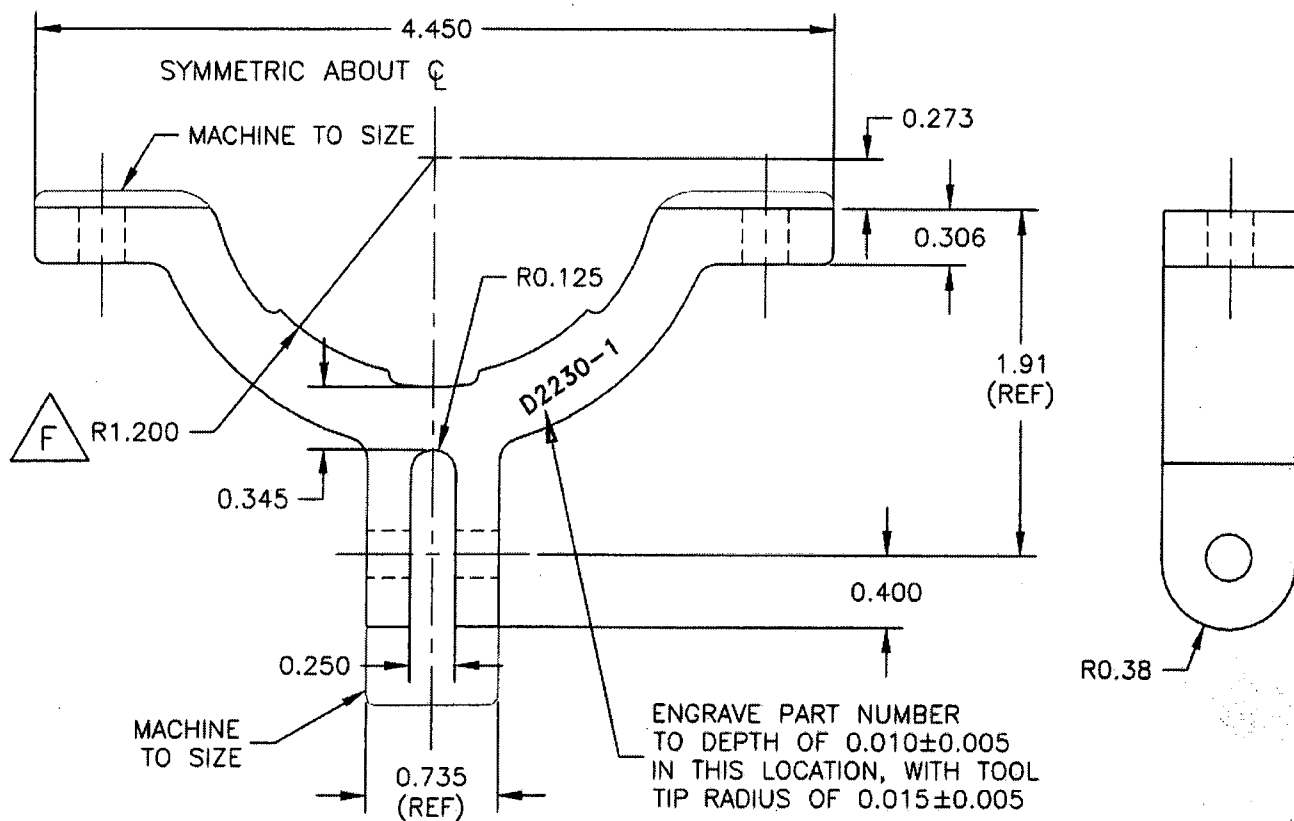
DA

D

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13	TITLE MOUNTING LUG		SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING

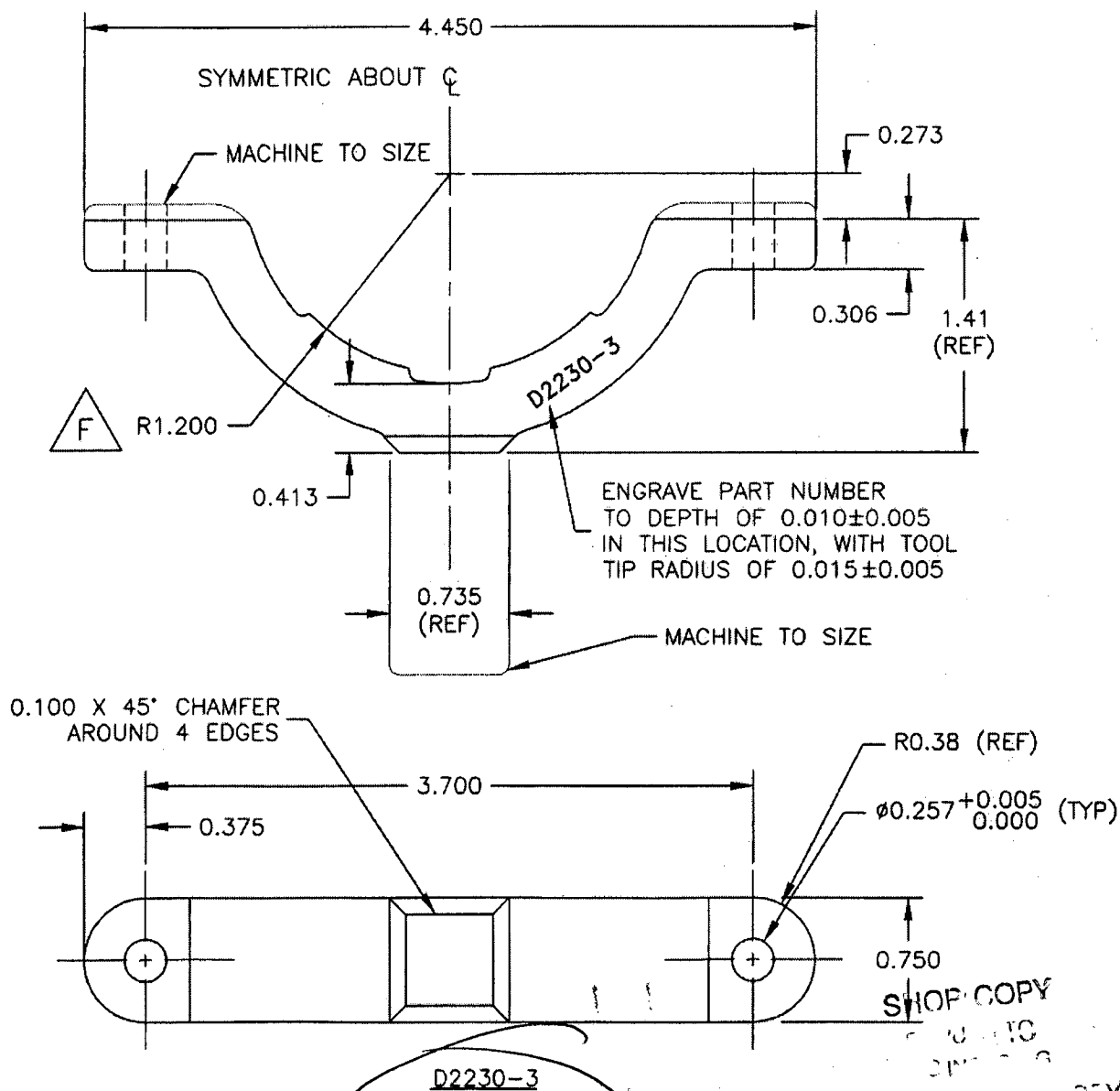
UNQUOTE COPY
SL T F
R C

WFO ORDER
24399



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

24399

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 03, 2005
11:23 am

Work Order No : 0024399
Project Name : D2230-3
Project For : WK543
Work Order Type : Main
Main WO Number :
House Part Number : D2230-3
Description : Mounting Lug
Manufactured : Yes
Amount Req'd : 200
Amount Done : 0
Start Date : 10-03-05
Est Finish Date : 10-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



CERTIFICATE OF COMPLIANCE

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:


same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
300	D 2230-3	Mounting Lug	2008788

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi (Regula) Walz

Vankleek Hill, November 14, 2005

